

Date: Friday, 2/23/2007 8:31:45 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARPAW CLAMP
 Job Number : 30886
 Estimate Number : 10622
 P.O. Number : *N/A* Part Number : D2882
 This Issue : 2/23/2007 S.O. No. : *N/A* Drawing Number : D2882 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 24505 Material : *N/A*
 Due Date : 3/30/2007 Qty: 200 Um: Each
 Written By :
 Checked & Approved By : *[Signature]*
 Comment : Est. B 02.01.17 Added laser cutting. NG/EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: *3165*Laser cut as per Dwg D2882 *CFI*

Mat'l AISI 304/316 SS .75 wide x .063 thick.

Material release note required

CL07/02/26 *(200)*

2.0 D2882B Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 200.0000 Each(s)

Clamp

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

CL07/05/13 *(200)*

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

(6.974 end to end" 6.174 center to center)

CL07/05/13 *(200)*
CL07/05/13 *(200)*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr any rough edges after tumbling

Form as per Dwg D2882 Use brake to form ends

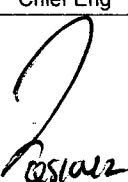
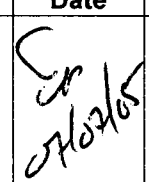

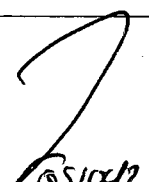
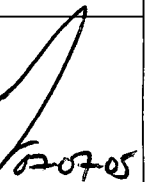
Finish form using DT8295

CL07/10/04 *(200)*

PTO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
020205	6.0	1 part was found with elongated holes 0.377x0.250 1 part appears to be crushed from pressing/forming.		Scrap: destroy. Verify all parts in the batch, for non-conforming parts				

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW CLAMP

Job Number: 30886

Part Number: D2882

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sn 07/07/06

counted

198

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble

N/A

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/7/5

199

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/07

Job Completion



07/07/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

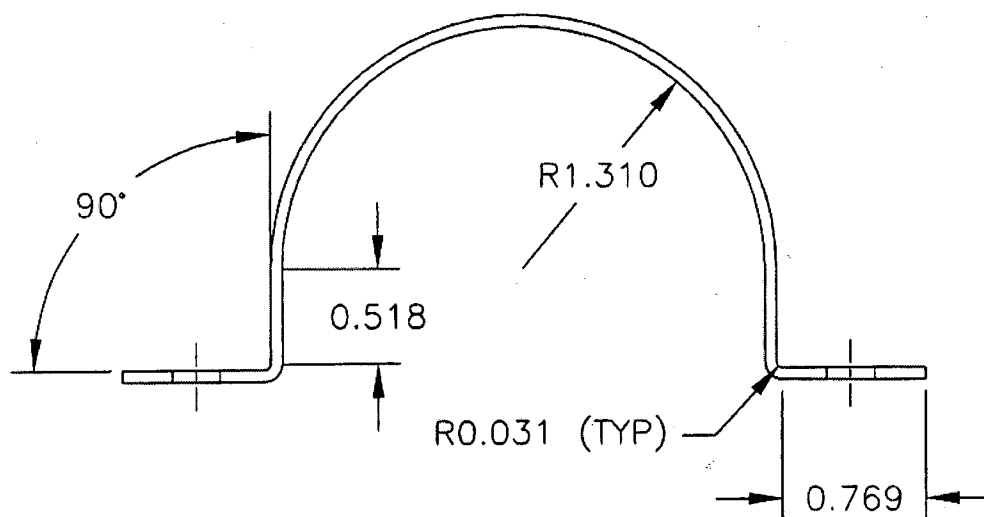
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

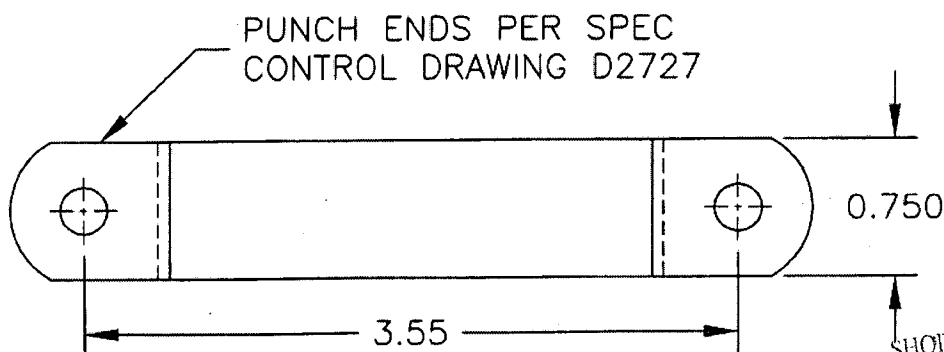


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>QA</i>	DRAWING NO. D2882	REV. A SHEET 1 OF 1
DATE 99.03.19		TITLE CLAMP	SCALE 1:1
A	99.03.19	NEW ISSUE	

RELEASED
29.04.12 KE



50(164)
+ 49(17)
+ 50
+ 50
199



FLAT LENGTH: 6.974 END-END
6.174 HOLE-HOLE

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
FORM ORDER
NO. 30886

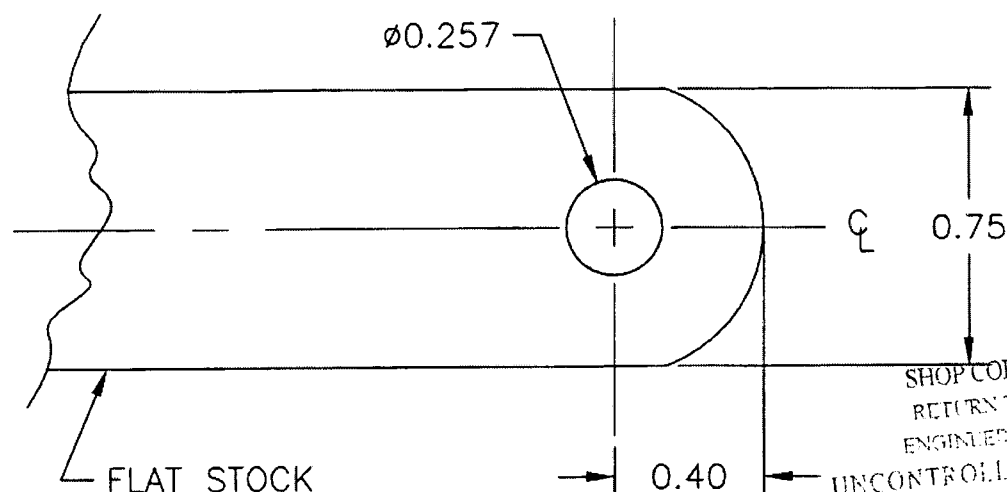
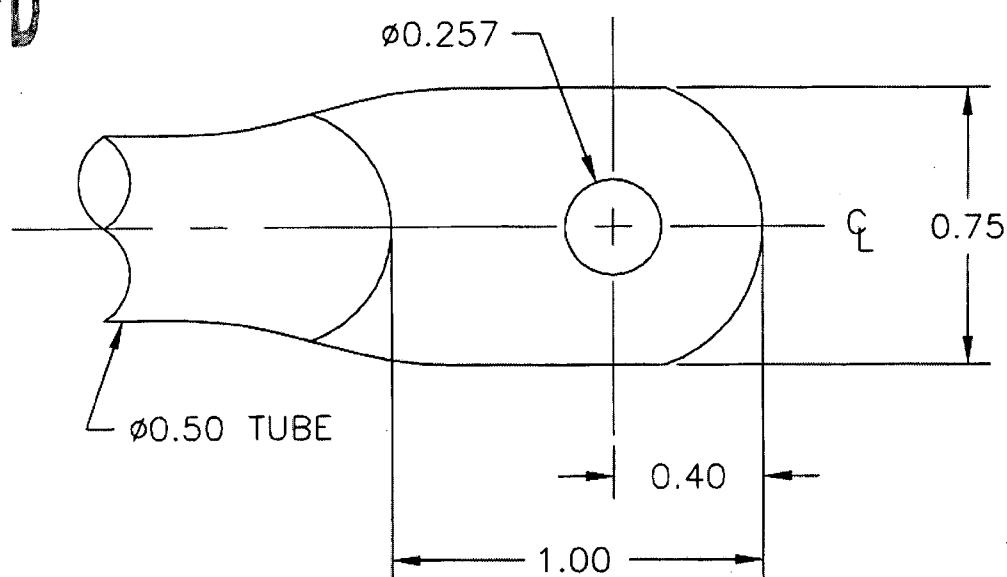
MATERIAL: AISI 304/316 SS 0.75 WIDE x 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED JA	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#CP 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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WORK ORDER
NO. 30886



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

C'est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

ENDU À / SOLD TO

DART AEROSPACE LTD
270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO.
2007/05/01	0364004

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO	N° COMMANDE PO NO	VIA SHIP VIA
DART GFI-0299		J0159867	PO00003165	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
200	D2882	CLAMP CERTIFICATE OF CONFORMANCE REQ <i>CP 05/03</i>		

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	1	OUR JOB NO	J0159867	SHIPPING MEMO	0364004	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
1	200 PCS	PQ00003165	D2880	A	CLAMP	A
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
SST 304		SIGMA METALS / A K STEEL		H/N # 7361663		
PROCESS			PROCESSOR		RELEASE NOTE #	
1 FIRST ARTICLE INSPECTION REPORT ON FILE			GFI		CONFORMS	
2						
3						
4						
5						
6						
7						
8						
9						

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 01 MAY 2007

G.F.I. Q.C. REP.

Robert H. N. H.



288-01



Sigma Metals Inc.
45 Jefryn Blvd.
Deer Park, NY 11729
A Small Woman Owned Business

(631) 243-2100 • (800) 471-7890 • Fax: (631) 243-3426

Packing Slip

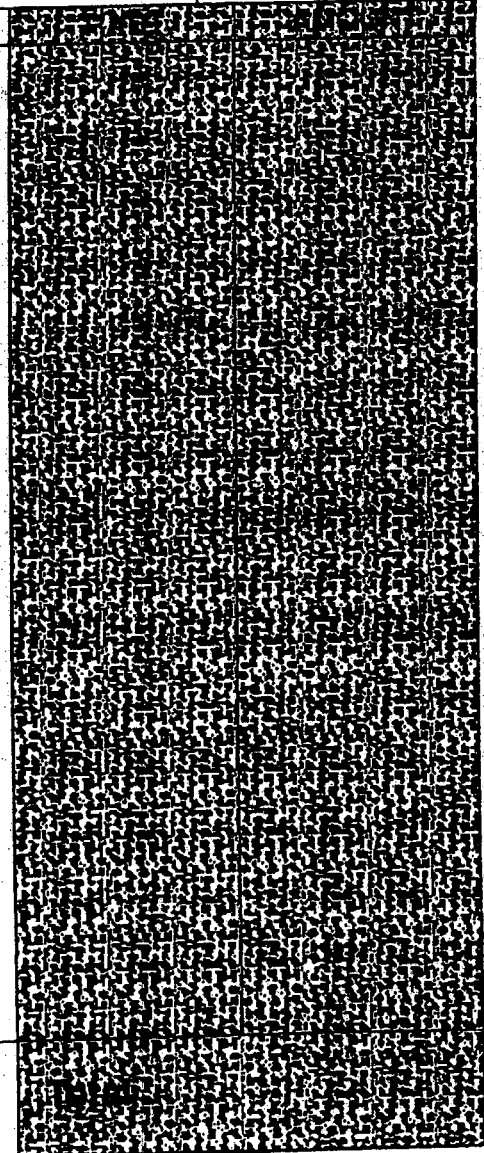
DATE 4/2/2007 INVOICE NO. 43543

BILL TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRE QUE, CANADA H9R 1A1

SHIP TO
GFI INC. 180 AVENUE LABROSSE POINT-CLAIRE QUE, CANADA H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0071346	Net 30	MEC	YELLOW	DEER PARK, NY	59881

ITEM	DESCRIPTION	QTY
SS T304	304 STAINLESS STEEL SHEET ANNEALED AMS 5513 .063" X 48" X 95' 168 LBS. MILL: AK STEEL LOT# 7361663 PRICED PER PC	2
	DOMESTIC CUSHPAK	1



[Handwritten signature]

GFI INC.

LE MATERIEL RECU NE SERA ACCEPTE
 QU'APRES VERIFICATION DE DIMENSIONS,
 EPAISSEUR, POIDS ET CONDITIONS.

SIGNATURE *[Signature]* DATE 05 APR 07

CERTIFICATE OF COMPLIANCE
 THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT
 STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A
 FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT
 ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT
 DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL
 REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST
 REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW
 THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED
 GREG SALADINO QC *[Signature]* Quality Control Manager

ORDER COPY WITH TEST REPORTS WITH SHIPMENT
 WE NOW ACCEPT VISA, MASTERCARD, AND AMERICAN EXPRESS



AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 1

Load No. 8304809

SRN No. 8304809

MILL. ORDER NO. 271940-0798
PROCESSOR ORDER NO. 01009471

PART NO.
00640

ENGLISH UNITS --PRODUCT-- METRIC UNITS
.0620 NOM 48.0000 X COIL

SKID ID	PIECE	HEAT	PARENT COIL ID	NET WEIGHT
SKD799032	1	7361663	0808293-02	16,080 LBS. 7,294 KG.
SKD799033	1	7361663	0808293-02	18,010 LBS. 8,169 KG.
TOTAL SKIDS	TOTAL PIECES			TOTAL NET WEIGHT
2	2			34,090 LBS. 15,463 KG.

L-Ladle Analysis of Heat

P-Product Analysis of Parent Coil

CHEMICAL ANALYSIS

ID	C	MN	P	S	SI	CR	NI	MO	N	CU						
L 7361663	.016	1.30	.028	.001	.45	18.35	8.58	.35	.036	.41						

SHIPPING DATE: 02/07/2007

REMARKS:

THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A.
NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA
SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING
ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.
COILED PRODUCTS CONTAIN NO WELDS
DEEP DRAW QUALITY

PRODUCT DESCRIPTION

CR SHT TYPE 302/304/304L STAINLESS #2B FINISH SLIT EDGE * AMS 5513 H * ASTM A 240 -06 (UNS S30400). * AMS 5511 H * AMS 5516 N *
ASTM A 666 -03 * MILS-5059 D-AMEND-3 * UNS-S30403 9TH EDITION * FMI-304L/304/302 ISSUE 7, 2/13/06 * ASME SA-240 SECTION II PAR
T A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-480 2004 ED APPLY * UNS-S30400/S30200

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	% ELONG 2 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. 2% OFFSET (KSI)	ROCKWELL HARDNESS Tall	ROCKWELL HARDNESS Front			
0808293-02	T	T	A.S.T.M	60.0	83.7	36.1	B 78	B 76			

REVIEWED BY Q.C.

Date 2/8/07 by *ea*

*** CONTINUED ON NEXT PAGE ***



AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 2

Load No. 8304809

SRN No. 8304809

MILL ORDER NO. 271940-0798
PROCESSOR ORDER NO. 01009471

PART NO.
00640

ENGLISH UNITS --PRODUCT-- METRIC UNITS
.0620 NOM 48.0000 X COIL

PARENT COIL ID	POS (F/T)	DIR (L, T, D)	COND	ASTM A 262 PRACTICE E	GRAIN SIZE ASTM E112	BEND 180 IT					
0808293-02	T		A.S.T.M	PASS	8.00	PASS					
0808293-02	F		A.S.T.M	PASS	8.00	PASS					

SIGMA METALS INC.

THESE TEST REPORTS APPLY TO:

GFI
P.O. 0071346
S/O 59881
PCS. 2 FTG
NET 168# DATE 4.2.07

THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT
AS CONTAINED IN THE RECORDS OF THE CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH A.S.T.M. STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

MW0020049 5/99

"THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONSIGNEE OF MATERIAL PURCHASED FROM AK
Steel Corporation. TO AVOID THE POSSIBILITY OF ITS MISUSE ON DELIVERY OF THE REPORT TO A
THIRD PARTY IT MUST BE RE-CERTIFIED BY AND UNDER THE NAME OF SUCH CONSIGNEE"

SIGNED

James Raymont
APPLICATION ENGINEER

DATE 02/08/2007 TIME 09:37 AM